

Date: Tuesday, 10/03/2009 10:50:50 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number : 46387	
Estimate Number : 13218	
P.O. Number :	Part Number : D212664201TRN
This Issue : 10/03/2009 S.O. No. :	Drawing Number : D212-664-241 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : CROSSTUBES	Drawing Revision : C
Previous Run : 46386	Material :
Written By :	Due Date : 17/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09.03.10</u>	
Comment : Est Rev:A 08-03-06 new issue DD verified by:ec Est Rev B 08.04.02 Removed polish EC verified DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6006129	Crosstube Material
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube 338338

Check OD = 3.250"; ID = 2.220"

A.M 09.03.12 ①

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3- File transition lines smooth.

A.M 09.03.12 ①

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEETA.M 09.03.12 ①

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2- File transition lines smooth.

3-Remove sand and plugs

A.M 09.03.12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 10:50:50 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 46387

Part Number: D212664201TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

4- scribe batch # and part # as per dwg

AM 09.03.12 ①

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

AM 09.03.12 ①

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

AM 9-3-16 ①

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

AM 9-3-16 ①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AM 9-3-16 ①

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and stock in kanban rack

Location:

X-TUBE CELL AM 9-3-16 ①

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AM 09.03.12 ①

Job Completion



AM 09.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46387
Description: Crosstube Assembly (205/212 High Aft)	Part Number: D212-664-241
Inspection Dwg: D212-664-241 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200 ✓			
	R0.063	+/-0.010	R0.063 ✓			
	2.990	+0.005/-0.000	2.993 ✓			
	5.237	+/-0.030	5.237 ✓			
	2.600	+0.005/-0.000	2.605 ✓			
	2.686	+0.005/-0.000	2.691 ✓			
	2.770	+0.005/-0.000	2.775 ✓			
	2.854	+0.005/-0.000	2.859 ✓			
	2.938	+0.005/-0.000	2.943 ✓			
	3.021	+0.005/-0.000	3.023 ✓			
	3.133	+0.005/-0.000	3.136 ✓			
	3.179	+0.005/-0.000	3.184 ✓			
SIDE B	0.200	+/-0.010	0.200 ✓			
	R0.063	+/-0.010	R0.063 ✓			
	2.990	+0.005/-0.000	2.993 ✓			
	5.237	+/-0.030	5.237 ✓			
	2.600	+0.005/-0.000	2.605 ✓			
	2.686	+0.005/-0.000	2.691 ✓			
	2.770	+0.005/-0.000	2.775 ✓			
	2.854	+0.005/-0.000	2.859 ✓			
	2.938	+0.005/-0.000	2.943 ✓			
	3.021	+0.005/-0.000	3.023 ✓			
	3.133	+0.005/-0.000	3.136 ✓			
	3.179	+0.005/-0.000	3.184 ✓			
	124.36	+/-0.020	124.365 ✓			

Measured by: a.m	Audited by: AWM	Prototype Approval:	N/A
Date: 09-03-10	Date: 9-3-16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJJ/JLM	
C	07.05.08	Dwg Rev. updated	KJJ/JLM	

DART**RELEASED**
07.04.24 P
PER E.L.N. 2259

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
NOTE: MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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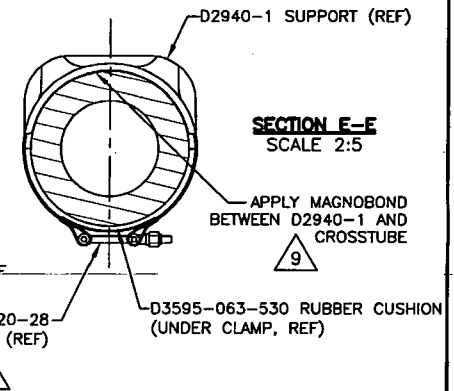
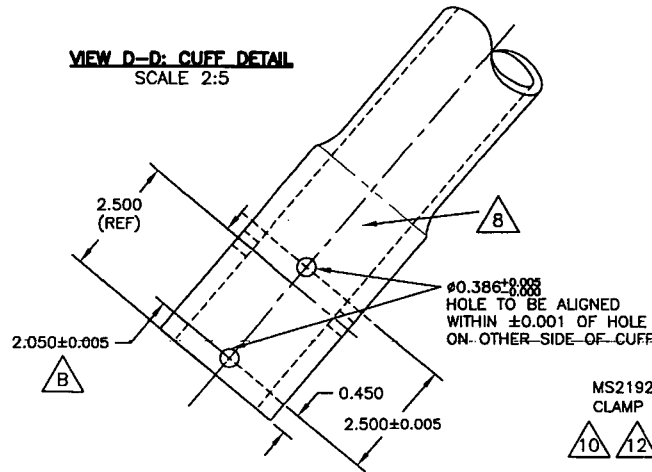
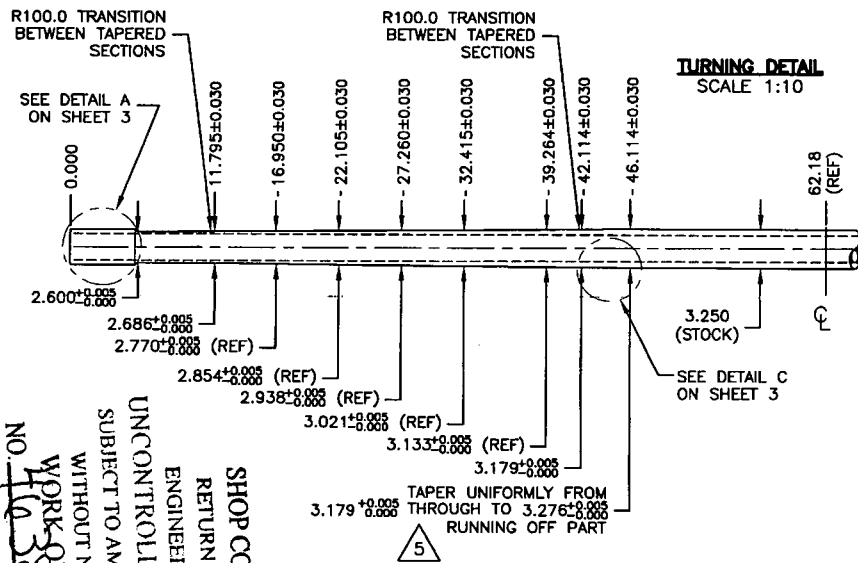
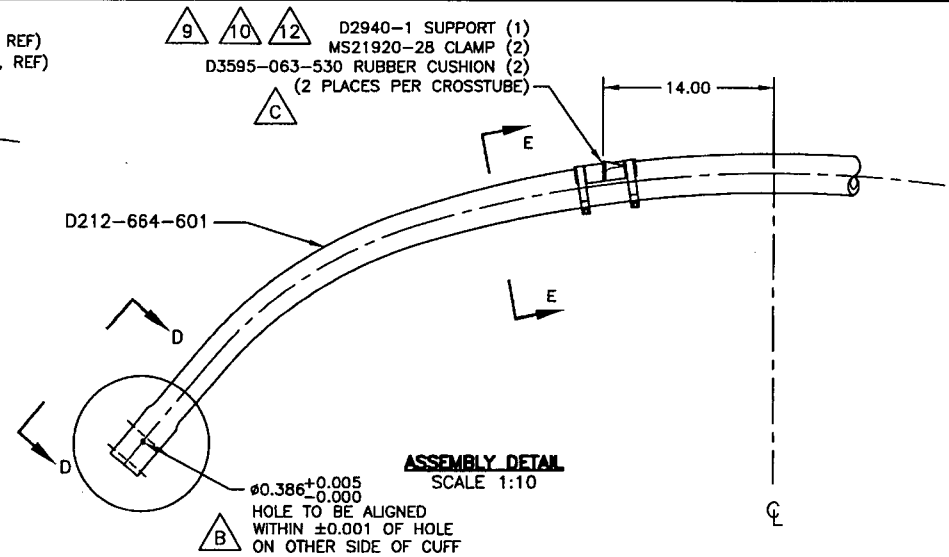
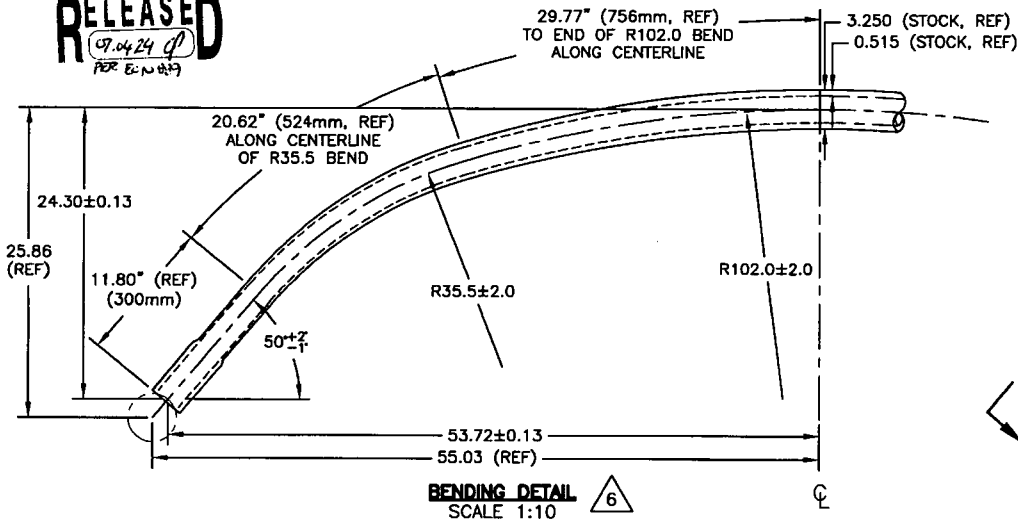
WORK ORDER

NO. 44387

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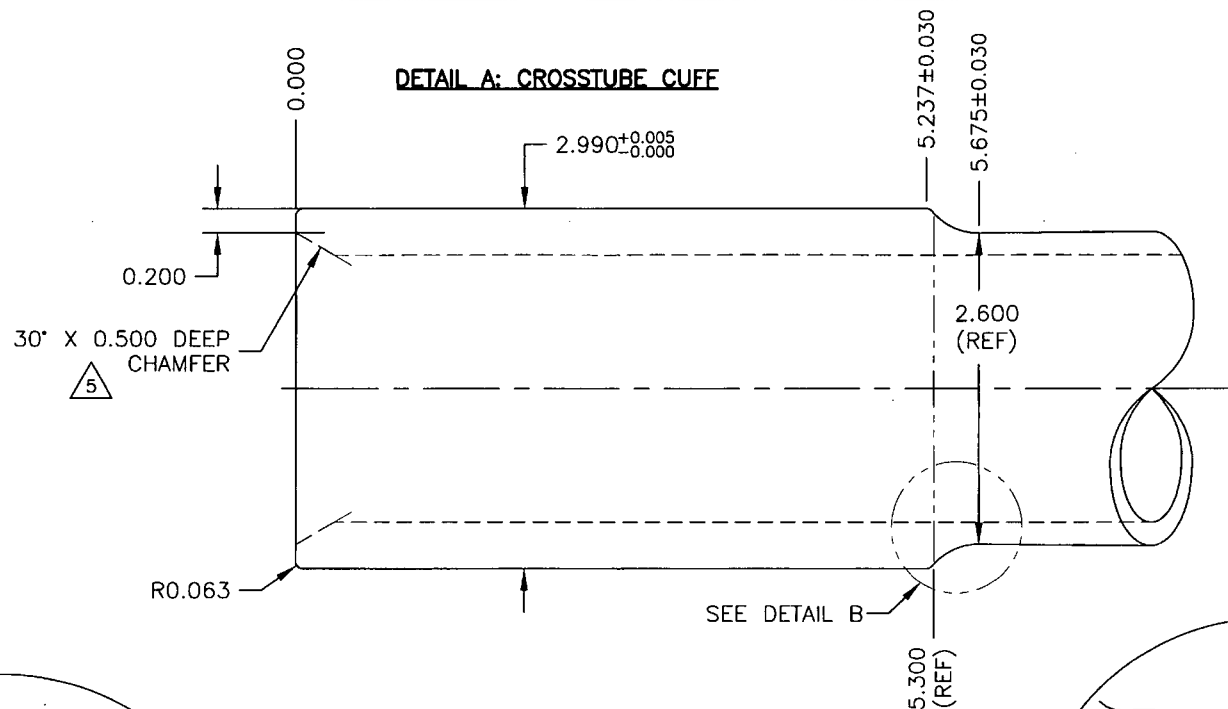
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CHECKED J	APPROVED J	DRAWING NO. D212-664-241	REV. C SHEET 2 OF 3
DATE 07.03.08	TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:10	

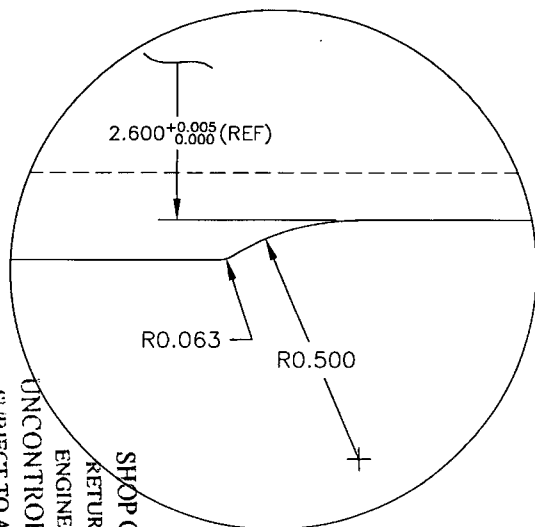
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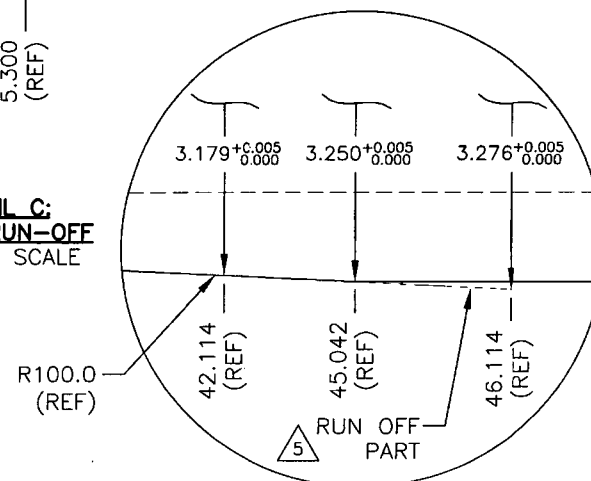
DETAIL A: CROSSTUBE CUFF



**DETAIL B: CUFF
TRANSITION
SCALE 4:1**



**DETAIL C:
TAPER RUN-OFF
NOT TO SCALE**



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		DATE		DRAWING NO.		REV. C
		07.03.08		D212-664-241		SHEET 3 OF 3
				TITLE		SCALE
				CROSSTUBE ASS'Y (205/212 HI AFT)	1:1	